Work Orde					Page 1						
Item ID: Revision ID:	D3916-041			Accept	*N900	040	100)* s	Setup Star	ıv	S1*
Item Name:	Rib Assembly							. *	Sto	*N	S2*
Start Date:	12/19/12	Start Qty: 2.00	*2*	•	Cust Item	ID:					
Required Date: Reference:	1/18/13	Req'd Qty: 2.00	*2*		Customer:					t,	
Approvals:	Process Pla	n:	Date: 12-UL	3 Tooling: _	D	oate:		F	Run Stai Sto	1/7	R1*
	QC:		_ Date:	SPC (Y/N):	D	ate:	 .		510	* N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D3916	A	:			•		•				
100				0.00							
100 Large Fab		Memo		0.00				<u> </u>	13.03	- <u>36</u>	PD.
Large Fab		*** Make I side of tube 3- Trim acc	e with manuel pipe bende	r other lines, and ensure se size as per dwg D3916	eam in place on						
105		QC6- Inspect dimension	s to drawing	0.00						, ,	·
105 QC Quality Control		Memo		0.00				lex	S.	4 13 6	3 26

NCR:	Yes / No	WORK ORDER NON-CONFOR
	, 23 / 110	

		***	•	-
DQA:	Date	٠.		_
<i>D</i> Q/1		· ·	1	١.
				\

NCR: Y	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE											
										QA Closed:	Date:	
Work Orde	er:				DISPOSITION	,			AGAINST DE	PARTMENT,	_	
Part N	lo	+ A			Rework Scrap Use-as-is	 _T	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo				Work Order Update			Large Fab	Composite		Supplier	
Root			Descri	ption of work order update	Init	ial	Acti	ion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data			į,									
Equip/Tooling										-		
Operator												
Material												
Setup												
Other												
Process			l									
Supplier												
Training												
Unapproved			<u> </u>									
						AULT (CATE	SORY				
Landir	ng Gear			_	General					7	· —	- 1
	Bending				Bend	\mathbf{H}	rain		<u> </u>	Ovalized		Pressure/Forced .
	─ ─	Not Conce	ntric to	o/s	BOM/Route	\vdash	ardwa		_	Over/Under	 	Temperature/Cure
ļ	Cracks				Broken/Damaged	-		on Incomplete	<u> </u>	Part Incorre	 	Weld
		/Crimped	,	<u> </u>	Burrs	-		ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			<u> </u>	Contamination	\vdash		nance	<u> </u>	Part Moved		
1	Heat Tre			<u> </u>	Countersink	\vdash	islabe			Positioned V		-n
		on Strip in	Tube	L	Cut Too Short	\blacksquare	isread			Power Loss/	Surge	Other
ļ	Ripples				Drill Holes	$\boldsymbol{\vdash}$	fset		•			
1		Waves in E		n	Drawing	-		Calibration				
	Turning	Sequence			Finish	Пог	ut of S	equence				<u></u>
	Wave/T	wist in Tul	oe .		Folio	Ou	Outside Dimensions					

Work Orde				*948			Page 2		
Revision ID:	D3916-041 Rib Assembly	·	A	ccept	*N900	N *	Setup Start	14771	
Start Date: Required Date: Reference:	12/19/12 1/18/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*	Cust Item ID: Customer:				_	
Approvals:	Process Pla QC:	n: <u></u>	•	Tooling: SPC (Y/N):	Da		Run Start Stop	"NRT"	
Sequence ID/ Work Center II 107 *107* Large Fab Large Fab)	Memo	rod Batch: 1123333 ning as per dwg D3916 ds flush	Set Up/ Run Hours 0.00	Tool ID	Tool# Plan Code	Accept Qty	t Reject Qty 3-04-D	Reject Insp. Number Stamp
*110 * QC Quality Control		QC5- Inspect part compl	eteness to step on W/O	0.00	13.4.2		6		

120

120

Memo

QC10- Inspect visual per QSI004- ground welds

0.00

CP(13.4.2

Quality Control

										DQA:	Date:			
NCR:	Yes / No)			WORK ORDER NON-C	CON	VFORM	MANCE / UPI	DATE					
					<u> </u>					QA Closed:	Date:			
Work Ord	er [.]				DISPOSITION AGAINST DEPA					PARTMENT	PARTMENT/PROCESS			
Part I	No				Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite				Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Well	1 0.)		Work Order opuate	」 		Large rab	composite	J	3upplie!	اــا		
Root				Descri	ption of work order update	1	nitial	Act	tion	Sign &				
Cause	Date	Step	Qty	(or Non-conformance Chief E			Desci	ription	Date	Verification	QC Inspector		
Doc/Data														
Equip/Tooling														
Operator												·		
Material						:						1		
Setup			1											
Other														
Process														
Supplier														
Training														
Unapproved												<u> </u>		
<u>-</u>						AUL	T CATE	GORY						
Landi	ng Gear				General					1	_	.		
	Bendin				Bend		Grain		<u> </u>	Ovalized		Pressure/Forced		
		Not Conce	ntric to	D/S	BOM/Route	\vdash	Hardwa			Over/Under	⊢	Temperature/Cure		
	Cracks			<u> </u>	Broken/Damaged	\vdash	-	on Incomplete		Part Incorre		Weld		
	_	d/Crimped		_	Burrs	\vdash		ions Incomplete/l	Jnclear	Part Lost/Mi	issing	Wrong Stock Pulled		
į	Cuffs			.	Contamination	\vdash	Mainte		<u> </u>	Part Moved				
	Heat Tr		- 1	-	Countersink	\vdash	Mislabe		<u> </u>	Positioned V		٦٠		
	Inspection Strip in Tube Cut Too Short						Misread Power Loss/Surge Other							
:		in Bend		<u> </u>	Drill Holes	\vdash	Offset					*		
	Torque	Waves in I	Extrusio	1 .	Drawing	1	Out of C	Calibration						

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord December-20-12				*948		Pa					
Item ID: Revision ID: Item Name:	D3916-041 Rib Assembly			Accept	*N900040100		•	Start Stop		S1* S2*	-
Start Date: Required Date: Reference:	12/19/12 1/18/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item ID: Customer:						
Approvals:	Process Pla QC:	n:	Date:	Tooling: SPC (Y/N):	Date:			Start Stop		R1* R2*	
Sequence ID/ Work Center II 130 *120* Packaging Packaging		Operation Description Identify as per dwg & Stock Memo	k Location: WA	Set Up/ Run Hours 0.00		Plan Acc Code Qty			Reject Number	Insp. Stamp	

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

140

*14**0***

Quality Control

MB-04-3

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-C	COI	NFORM	MANCE / UPDATE		·		
											QA Closed:	Date:	
Work Ord	er.					DISPOSITION	DISPOSITION AGAINST DE					/PROCESS	•
Part				· · ·		Rework Skid-tube Crosstube Scrap Machining Small Fab					Water Jet d. Eng. Coor.	Engineering Quality	
NCR No.						Use-as-is Work Order Update		inern	noforming Fini Large Fab Comp	shing posite	Rec/Stor	re/Packaging Supplier	Other
Root					Descri	ption of work order update		Initial	Action	,	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data	L												
Equip/Tooling													
Operator							1						
Material									<u>.</u>				
Setup]											
Other]											
Process												•	
Supplier													
Training	П												
Unapproved													
						F	ΑUL	T CATE	GORY	_			
Landi	ng (Gear				General		_			_		_
		Bending			ļ	Bend		Grain	4		Ovalized		Pressure/Forced
	Centre Not Concentric to O/S BOM/Route						L	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks Broken/Damag							Inspecti	on Incomplete		Part Incorre	ct .	Weld
		Crushed/0	Crimped,			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		_
		Heat Trea	t			Countersink	Γ	Mislabe	led		Positioned Wrong		
	Inspection Strip in Tube Cut Too Short							Misreac	I		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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Picklist Print

December-20-12 9:12:09 AM

Page 1

Work Order ID:

94818

Parent Item:

D3916-041

Parent Item Name:

Rib Assembly

Start Date: 12/19/12

Required Date: 1/18/13

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP RevA: New issue DD verified by:EC verified by:EC

IPP Rev:B as per dwg revA 10.03.15

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit		Qty	Date	Status
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand		Qty	Issued	Issued	
D3759-1		Manufactured	No			100	Each	246.0000	7	-14-	3) ×	2 ~ 2 ~	- ON
Bushing						,				-g		<i>5-03-</i> 9	<u> </u>
		-		Location		Loc Oty	<u>L</u>	oc Code					•
				WA004		246			Ber	3 336 -) त्र		
	·			66489		. 1							
				7921	•	1							
				83464 86550		20			-				
•				8978		11				_ .			
				9078	5	206							
M304TS0.750W.049		Purchased	No			100	f	905.1312	4.166	8.77052	63		0
304 SQ Tube .75x.75x.049	ew .								'	3.6313	, ,	<u>3-03-</u>	32 1
				Location		Loc Qty	<u>L</u>	oc Code					
				MAT017		2.0156214			W13.	<u>4442</u>	-> 63	15"1	
	3			1218	98	2.0156214							
				WA006		903.1155859							
				1222		0.1626							
				1224 1226		39.0000000 0.7293							
				1227		20.5							
	•			1232		289.5							
				(1234	84)	553.223686			124	-345 6.	3157		

										DQA:	Date:					
NCR: Y	es /	No No				WORK ORDER NON-C	CONFOR	ONFORMANCE / UPDATE QA Closed: Date:								
Work Orde	ar.					DISPOSITION			AGAINST DE	PARTMENT	PROCESS					
Part N	 lo					Rework Scrap Use-as-is Work Order Update	1 1	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Composite			Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other				
Root		·			Descri	ption of work order update	Initial	Ac	ction	Sign &	·					
Cause		Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector				
Doc/Data																
Equip/Tooling																
Operator																
Material																
Setup [
Other																
Process																
Supplier [่ .							1								
Training			-		•			1	:							

Pressure/Forced Bending Bend Grain Ovalized BOM/Route Temperature/Cure Centre Not Concentric to O/S Over/Under tolerance Hardware Broken/Damaged Part Incorrect Weld Inspection Incomplete Cracks Wrong Stock Pulled Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Cuffs Contamination Maintenance Part Moved Mislabeled Positioned Wrong Heat Treat Countersink Other Misread Power Loss/Surge Inspection Strip in Tube Cut Too Short Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Folio Wave/Twist in Tube Outside Dimensions

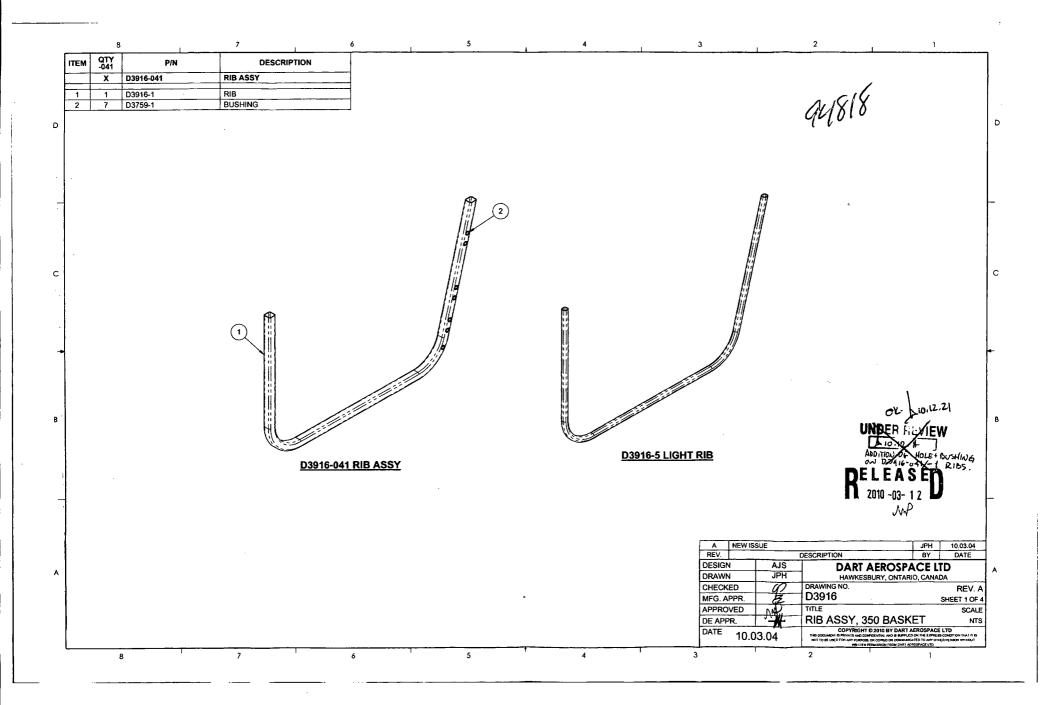
FAULT CATEGORY

General

Unapproved

Landing Gear

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8 D -D3916-1 RIB D3759-1-BUSHING 7 PL D3916-041 RIB ASSY DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT -041: 1.84 lbs
8) WELD PER DART QSI 004 AJS DRAWN JPH 9 CHECKED DRAWING NO. REV. A D3916 MFG. APPR. SHEET 2 OF 4 APPROVED TITLE SCALE RIB ASSY, 350 BASKET NTS

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